

Date: Thursday, 07/08/2008 4:23:24 PM  
 User: Julie Lecocq

## Process Sheet

SPLIT-2

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 41068	Part Number	: D3560043
Estimate Number	: 12883	Drawing Number	: D3560 REV D
P.O. Number	:	Project Number	: N/A
This Issue	: 07/08/2008 S.O. No. :	Drawing Revision	: D
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : MACHINED PARTS	Due Date	: 26/08/2008
Previous Run	: 40300	Qty:	10 Um: Each
Written By	:		
Checked & Approved By	: JLP 08.8.08		
Comment	: Est Rev:A New Issue 07.05.24 EC		
	: Est Rev B ECN 987 07.10.09 EC		
	: Est Rev:C ECN1048 07-12-18 DD verified by: EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X05000	6061-T6 Bar .500 x 5.00
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Comment: Qty.: 1.3598 f(s)/Unit Total: 13.5975 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: W/08854

J.L 08/08/24

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks 15.500" long

J.L 08/08/24

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA695 Rev: AA &amp; Dwg D3560 Rev: D

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

DIP 08/08/26

(12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 08/08/27

(12)





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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 41068

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 08/09/02 (2)

6.0

D35921

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

PLATE

B 42279

SP 08.09.30

(2x)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

### STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad ) SP
- 2- set up bracket and arm on jig SP
- 3- preheat bracket and arm with torch SP
- 4- clean before welding with brush SP
- 5- set up machine to 135 amps SP
- 6- weld across bottom and top ends SP
- 7- reheat with torch ( 65 deg C ) SP
- 8- on one side weld from bottom to top half way SP
- 9- same for other side (half way) SP
- 10- from half way point weld the rest of the first side (ease off pedal near end) SP
- 11- same for remaining side (ease off pedal near end) SP

SP 08-09-30 (2x)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 10.01 (2)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SD 08-09-30 (2)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SP

08-10-01

(2x)





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Drawing Name: ARM

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Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(2x)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-f 08/10/02

12.0

D2808

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Spacer

batch:

B37113

08/10/02 (2)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

08/10/02 (2)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/02 (2)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

152

8/10/02

(2x)

SD

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/03 H

Job Completion



u 08.10.03





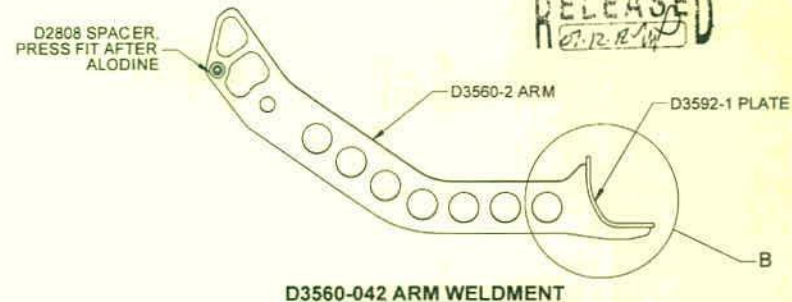
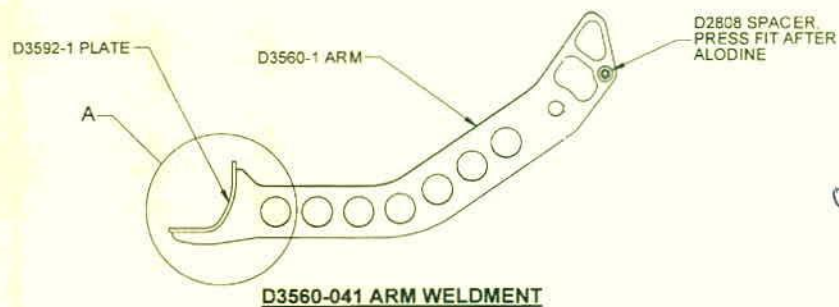




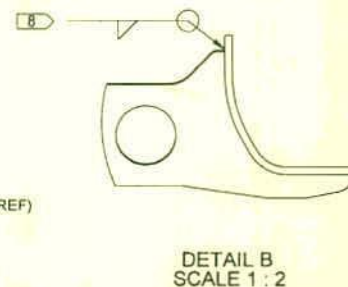
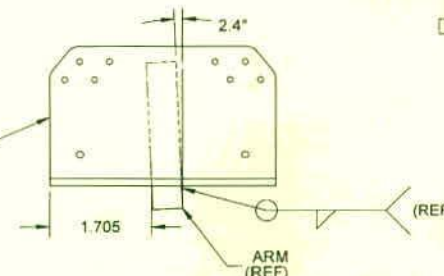
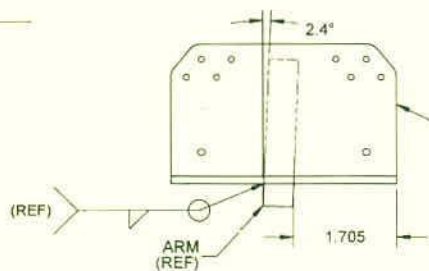
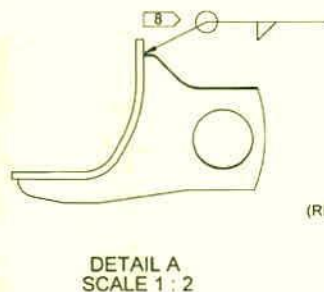
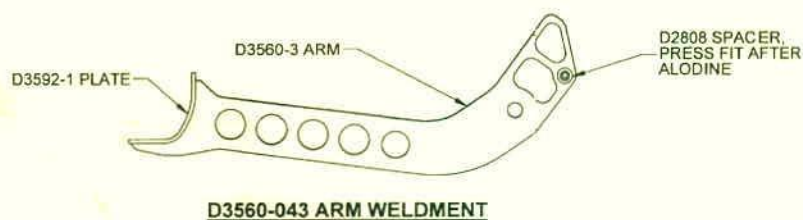


REFERENCE ONLY

RELEASED  
07.12.16



89017 g/m



PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.23 lbs (TYP)
  - 8) WELDING: PER DART QSI 004

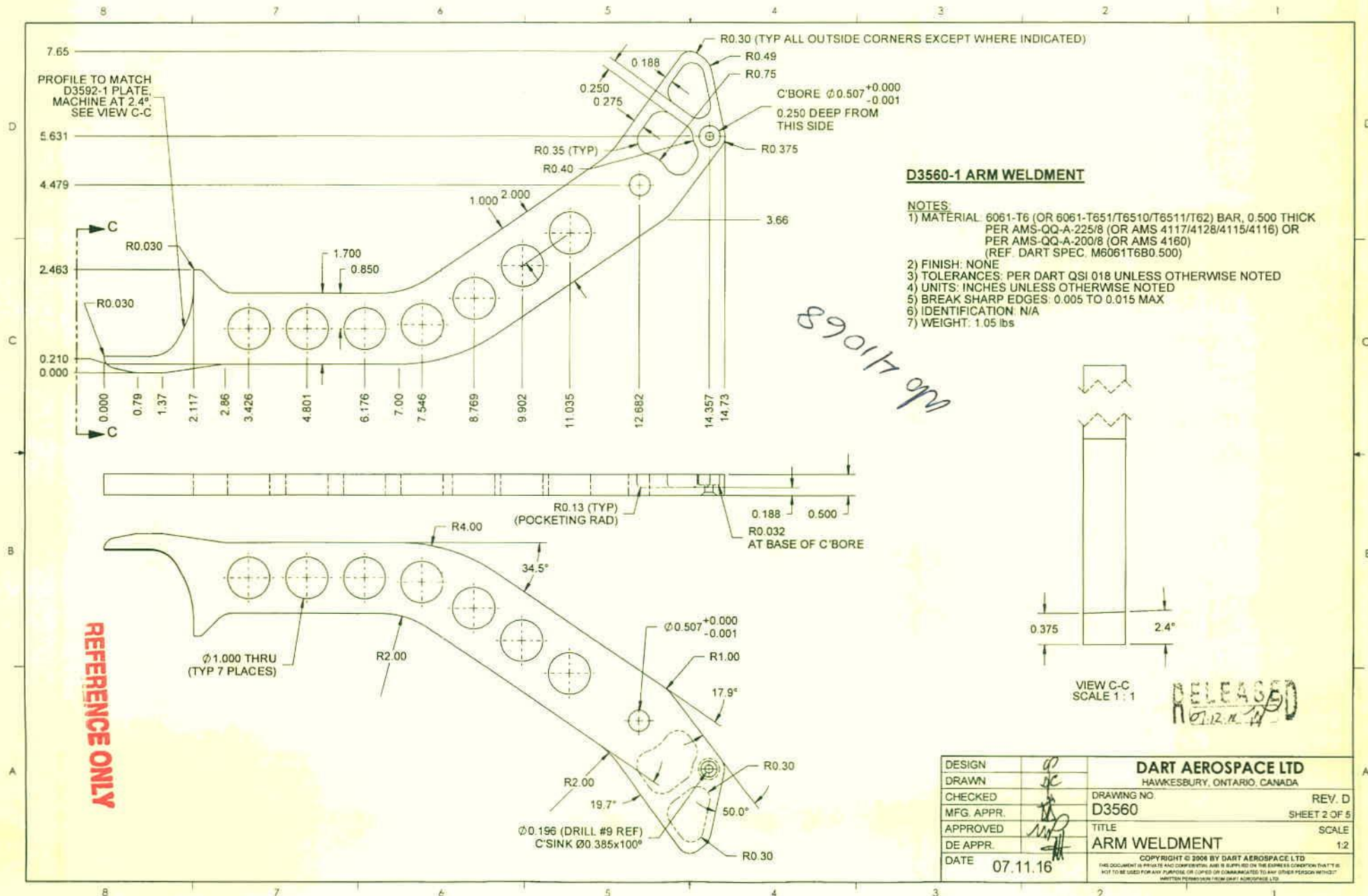
DESIGN	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
DRAWN	REMOVE POWDER COAT	CP	07.06.19
CHECKED	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
MFG APPR.	NEW ISSUE	CP	06.09.25
APPROVED		BY	DATE
DE APPR.			
DATE	07.11.16		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3560</b>	REV. D SHEET 1 OF 5
TITLE <b>ARM WELDMENT</b>	SCALE 1:4
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SECRET/SECRET OMTA



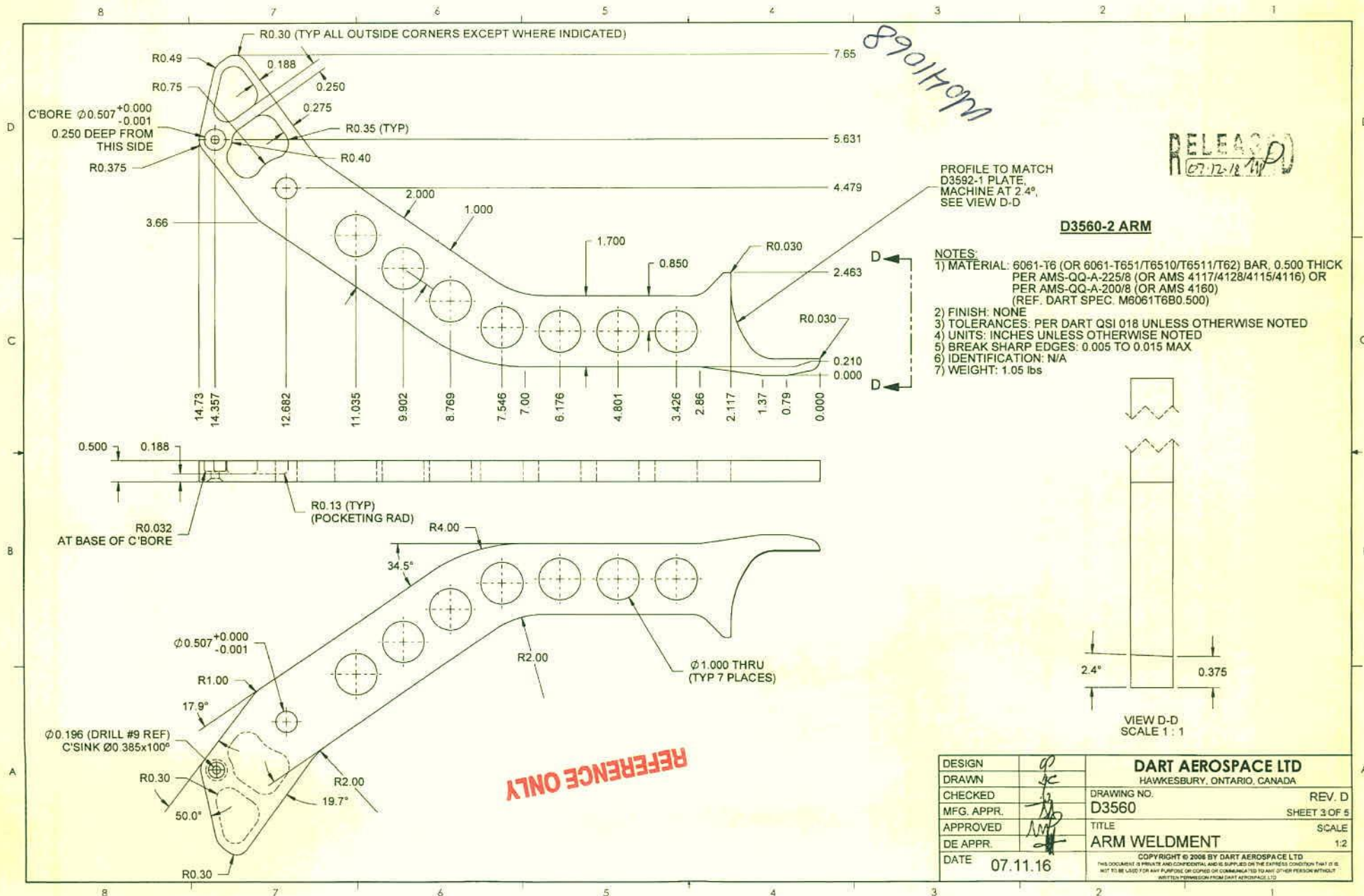
# **D3560-1 ARM WELDMENT**

## **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4180)  
 (REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs

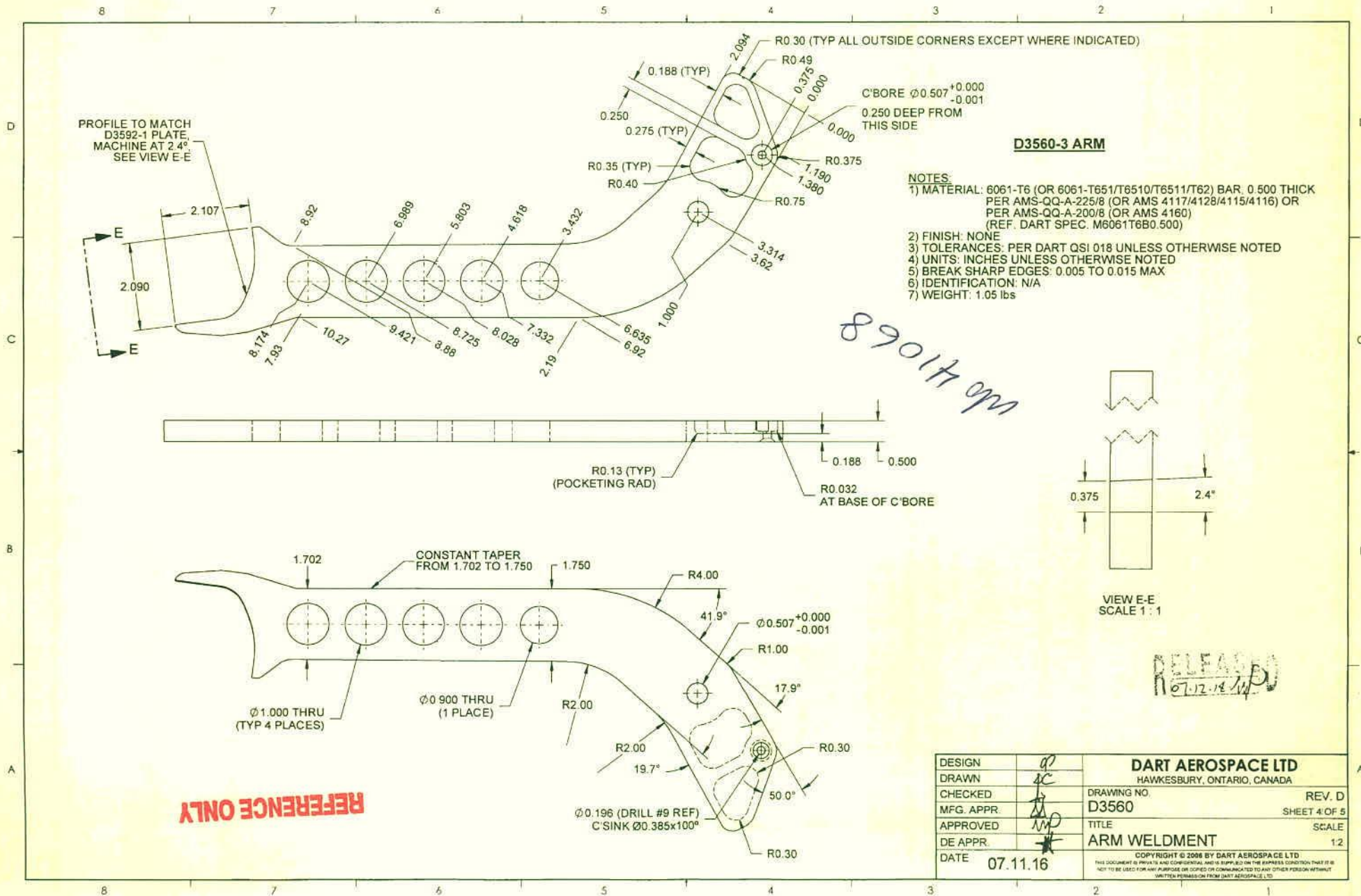


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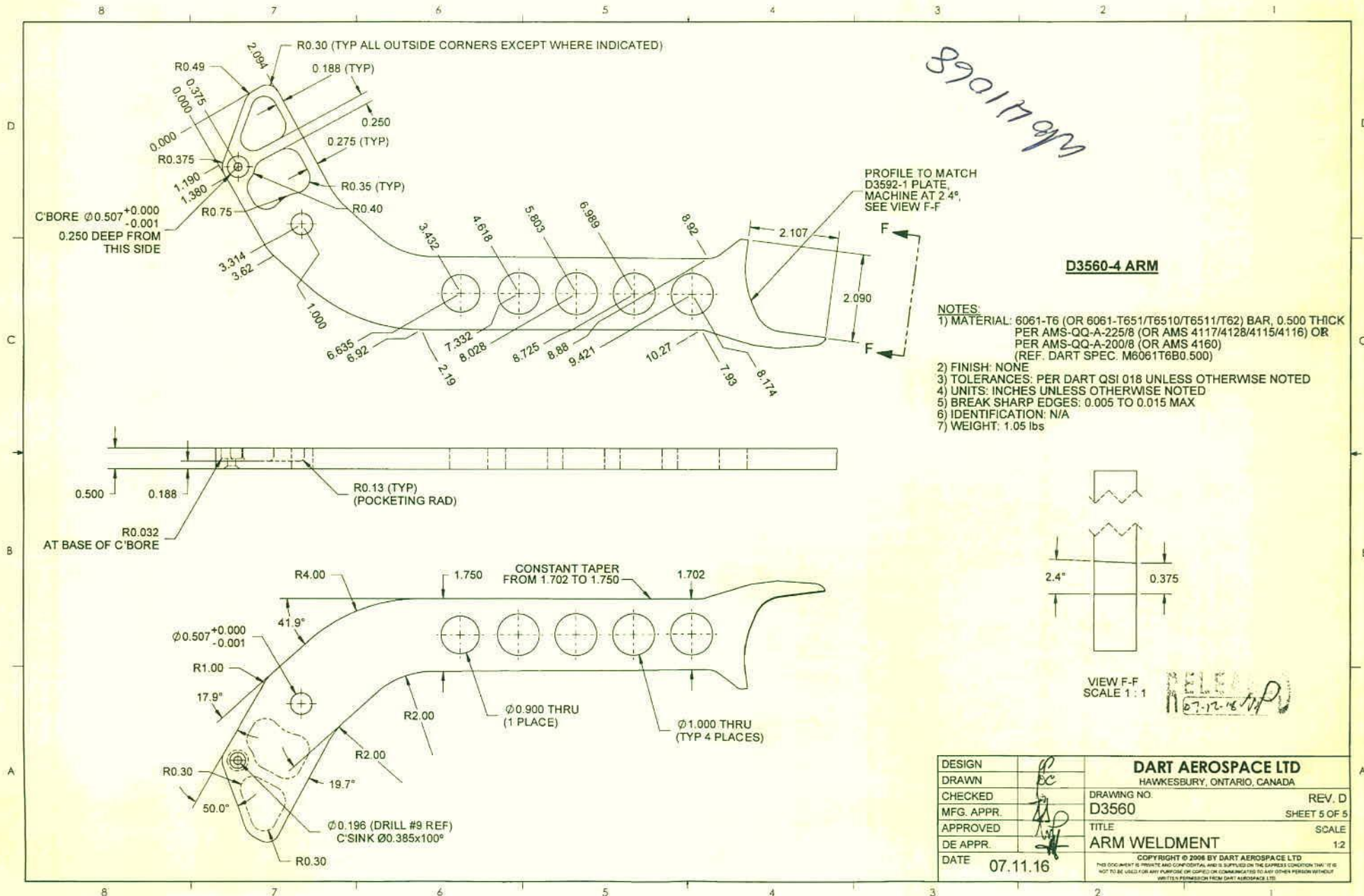












DESIGN	BC	<b>DART AEROSPACE LTD</b>	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3560	SHEET 5 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	ARM WELDMENT	1:2
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